

Work Order ID 68092

Wednesday, April 06, 2011 12:57:39 PM

mid next week Apr 12th
-13th Page 1

Item ID: D350-591-113

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Short

Stop



Start Date: 4/6/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-04-06

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2310

D

DSI 9525

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-591-113

CHG005

Salazar

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310
2-Drill extrusion as per Dwg D2310 using drill Jig DT8230
3-Deburr

11-04-06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

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Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Weld Fwd end cap and bushing as per Dwg D2310
A/R AL ROD Batch: M114703
2-Grind end cap and bottom bushing welds flush
3-Machine top weld on bushing flush

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control



0.00 *8 ulorlog*

(4)

0.00

11-04-07

1 0

1 0 BEN/04/07

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

Quality Control

160 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish

Memo

Hand Finishing

165

QC3

170



Large Fab

Large Fab

Memo

Large Fab

1-Rivet as per Dwg D2310
2-Inspect for foreign object as per QSI 024
3-Weld Aft end cap as per Dwg D2310
A/R AL ROD Batch: M114703
4-Grind end cap welds flush

0.00 *8/10/07*

0.00

0.00

0.00

11.04.07

M. 11/04/07

11.04.07

(1X)

(1X)

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00

8/11/04/08

QC

Memo

0.00

Quality Control

190

QC5- Inspect part completeness to step on W/O

0.00

8/11/04/08

QC

Memo

0.00

Quality Control

200

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

1 BR 11-4-8.

W/O:		WORK ORDER CHANGES						
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Required Date: 4/13/2011 Req'd Qty: 1.00




Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M 11/6 964.</i> Memo START TIME: <i>10:00</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>10:30.</i>	0.00 0.00				<i>1</i>		<i>BL 11-4-8.</i>	
220  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>M 11/6 402.</i> Memo	0.00				<i>1</i>		<i>BL 11-4-8.</i>	
230  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>M 11 04 08</i>		<i>(1)</i>	

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Cust Item ID:

Required Date: 4/13/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

250

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

260

PACKAGING RESOURCE #1

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-113
Location: _____

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 4/13/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/04/08
MF

11-04-08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, April 06, 2011 12:57:35 PM

Page 1

Work Order ID: 68092

Parent Item: D350-591-113

Parent Item Name: Heli-Access-Step, Short



Start Date: 4/6/2011

Required Date: 4/13/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:HL:04.11.09 Reformat KJ/JLM
ECN10-586 10.06.18 DD verf:EC

IPP Rev:E as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116 Step Extrusion		Manufactured	No			110	Each	163.0000	1	1		11.04.06	
---------------------------------	--	--------------	----	--	--	-----	------	----------	---	---	--	----------	--

Location	Loc Qty	Loc Code
HALL	97	
60307	97	
WA	66	
57850	19	
60307	47	

D2275 Bushing		Manufactured	No			130	Each	30.0000	1	1		11.04.07	
----------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA015	30	
27755	30	

D2582 Step Leg Assembly		Manufactured	No			170	Each	9.0000	1	1		11.04.07	
--------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA014	9	
62053	3	
67214	6	

W/O:		WORK ORDER CHANGES						
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• Picklist Print

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Page 2

Work Order ID: 68092

Parent Item: D350-591-113

Parent Item Name: Heli-Access-Step, Short

Start Date: 4/6/2011

Required Date: 4/13/2011

Start Qty: 1.00

Required Qty: 1.00

D2673-34 Manufactured No

130

Each

111.0000

2

2



End Plate



4/11.04.07

Location

Loc Qty

Loc Code

WA015

111

59690

111

2

K591-113 Manufactured No

240

Each

0.0000

1

1



Short Step Instln Kit

MS20600-AD4W3

Purchased No

170

Each

931.0000

16

16



Cherry Rivets



4/11.04.07

Location

Loc Qty

Loc Code

ST321

494

111636

494

WA018

437

107939

437

16

Wednesday, April 06, 2011 12:57:36 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2310	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

68092

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16 ^{2"}

*cut per drawing

RELEASED
05.11.28 *[Signature]*

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

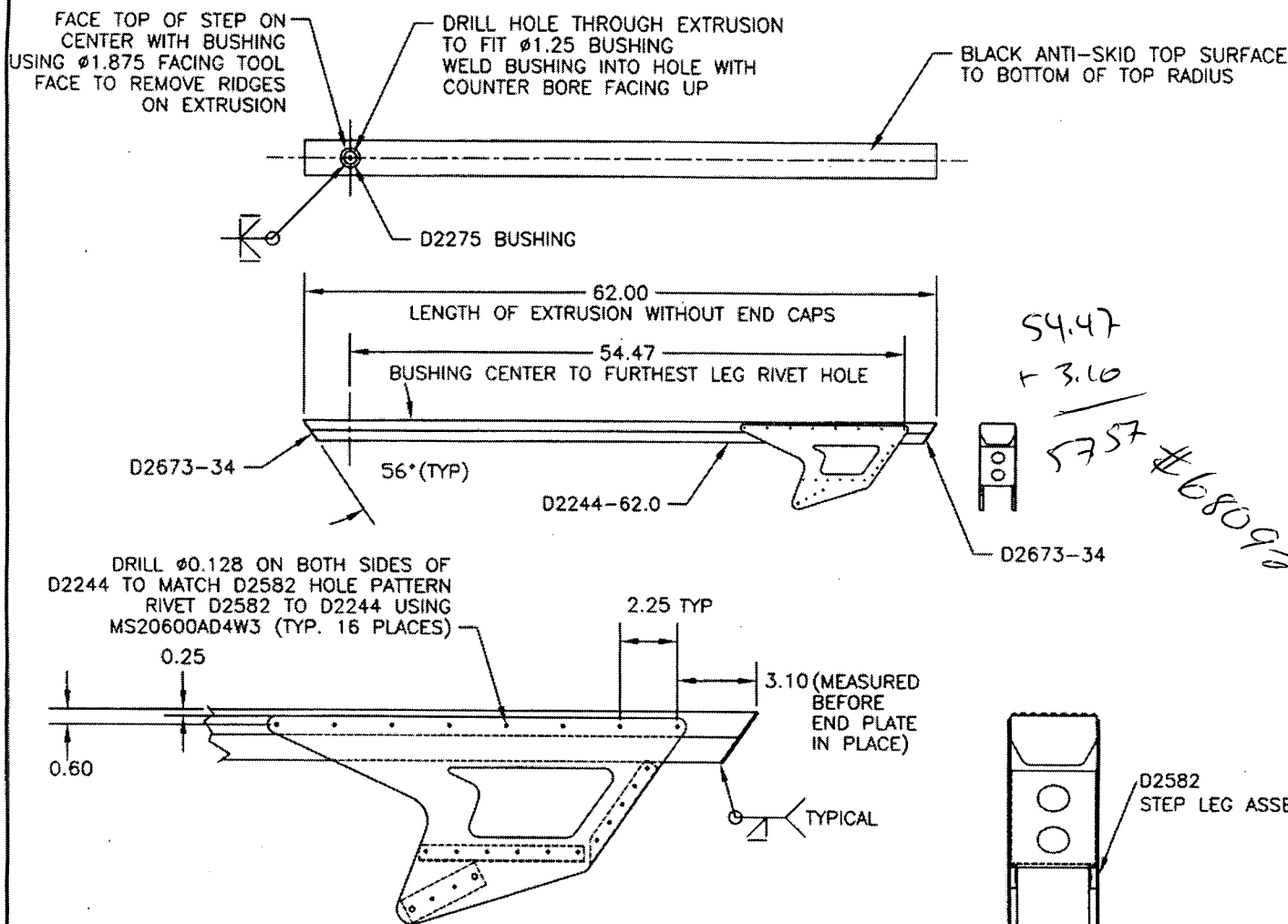
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2310	SHEET 2 OF 2
DATE 05.11.14	TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS	



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-11-28

W/O:		WORK ORDER CHANGES						
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